

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028357**Date Inspected:** 08-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

OBG 12W

This QA observed the following welders working in OBG 12W at various locations:

Authorized welder Chris Bruce #8901:

Welder Chris Bruce was observed welding on welds 12W PP114 W2.1-BW2 (3G, CJP) and 12W PP114 W2.1-BW1 (3G, CJP). The welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030; preheating to the specified temperature of over 150 degrees prior to welding. Other welding parameters observed were as per Welding Procedure Specification's (WPS) noted above and appears to be in order.

Authorized welder Eric Sparks #3040:

Welder Eric Sparks was observed performing weld repairs on weld 12W PP111.1-B1. The weld was excavated at multiple Y locations before welders were forced to stop and wait for "Request for Weld Repair" (RWR) approval before taking additional steps. Welder was observed performing proper preheating requirements prior to carbon arc gouging (CAG).

This QA randomly observed QC Inspectors Barry Drake and Patrick Swain checking WPS compliance of welders

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

throughout the day and performing Visual Testing (VT) on items as they become available.

Magnetic Particle Testing

This QA performed Magnetic Particle Testing (MT) on the following welds:

12W 13W-B1:

- 100% Final MT (A & B Sides, MT Accept.)

12W PP114 W2.1-BW1:

- 100% Back Gouge MT (1420mm, MT Accept.)

12W PP114 W2.1-BW2:

- 100% Back Gouge MT (640mm, MT Accept.)

Ultrasonic Testing Shear Wave

This QA performed Ultrasonic Testing Shear Wave (UTSW) on the following weld:

12W 13W-B1:

- 10% Final UTSW (A Side, UT Accept.)

The above welds were previously accepted by QC Magnetic Particle technicians. This QA observed no rejectable indications at the time of testing. This QA Inspector generated an MT and UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

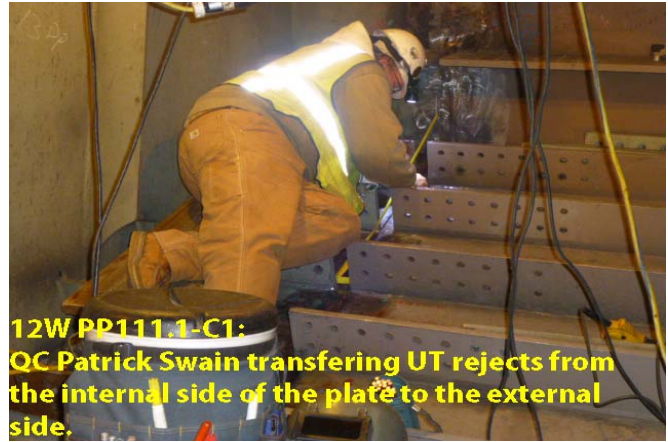


WELDING INSPECTION REPORT

(Continued Page 3 of 3)



12W PP114W2.1-BW2:
Welder Chris Bruce #8901 welding 3G on panel
point 114 web splice.



12W PP111.1-C1:
QC Patrick Swain transferring UT rejects from
the internal side of the plate to the external
side.

Summary of Conversations:

Conversations relevant to work performed on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
